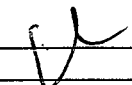
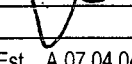


Date: Thursday, 19/04/2007 1:46:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CHAFING SHIELD
Job Number	: 31959		
Estimate Number	: 12815		
P.O. Number	: N/A	Part Number	: D31893
This Issue	: 19/04/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3189 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31952	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	: JUA
Written By	: 	Due Date	: 20/04/2007
Checked & Approved By	: 	Qty:	5 Um: Each
Comment	: Est. A 07.04.04 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S25GA	304/316 .020" Sheet
-----	-----------	---------------------



Comment: Qty.: 0.2205 sf(s)/Unit Total: 1.1025 sf(s)

304/316 SS .020" Sheet

(M304S25GA)

Batch: M102393

mf 07-04-19

PTC 5

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Cut to size as per Dwg D3189

mf 07-04-19

5

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr & Grind Rads as per Dwg D3189

2-Roll as per Dwg D3189

mf 07-04-19

5

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SB 07104/19

5

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C/B 07/04/20 5

Date: Thursday, 19/04/2007 1:46:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CHAFING SHIELD

Job Number: 31959

Part Number: D31893

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/08

Job Completion

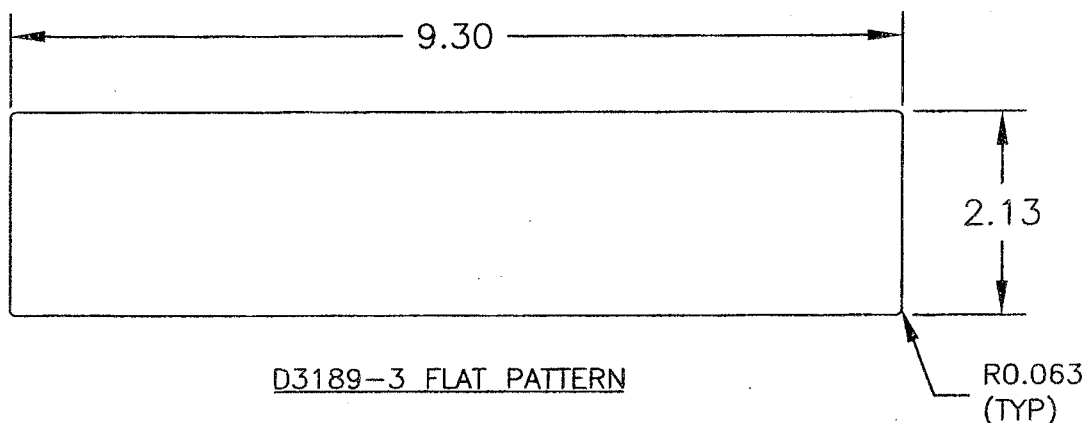


✓ 07-04-08

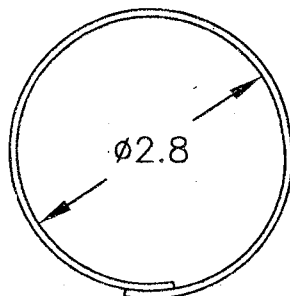


DESIGN 92	DRAWN BY 92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

07.03.27 [Signature]



D3189-3 FLAT PATTERN



D3189-3 ROLLING DETAIL
NOT TO SCALE

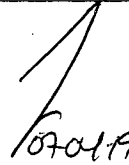

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31459

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-19	1.0	NOOQO in stock, acceptable to use 304 SS. 2664				 07-01-19	 07-01-19

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/01/2019

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

